

Step 25-26/05

Work Order ID 59020

May 25, 2010 6:59:50 AM



Page 1

Item ID: D3955-5

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/25/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3955	A

100	0.00
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Waterjet

Memo

0.00

10-5-25

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary



110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

10-5-25

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59020

Page 2

May 25, 2010 6:59:50 AM

Item ID: D3955-5

Accept



Setup

Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/25/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

10/05/25

0.00



QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: 103

0.00



Packaging

Memo

Packaging

10-5-25

504

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/05/25

10-5-25

5

W/O:		WORK ORDER CHANGES					
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Picklist Print

May 25, 2010 6:59:49 AM

Page 1

Work Order ID: 59020



Parent Item: D3955-5



Parent Item Name: Plate

Start Date: 5/25/10

Required Date: 5/26/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	64.8548	0.3545	1.865789	2.0	1210-5-05	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	64.8548	
111323	0	
114467	64.8548	114467

1210-5-05

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DART AEROSPACE LTD	Work Order:	<i>59020</i>
Description: Plate	Part Number:	D3955-5
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-5-24</u>	Date: <u>10/05/24</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
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8

7

6

5

4

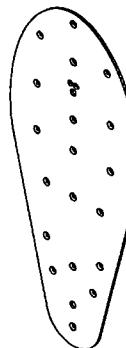
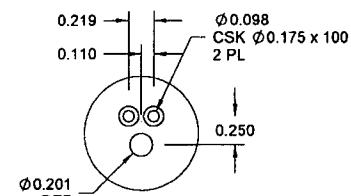
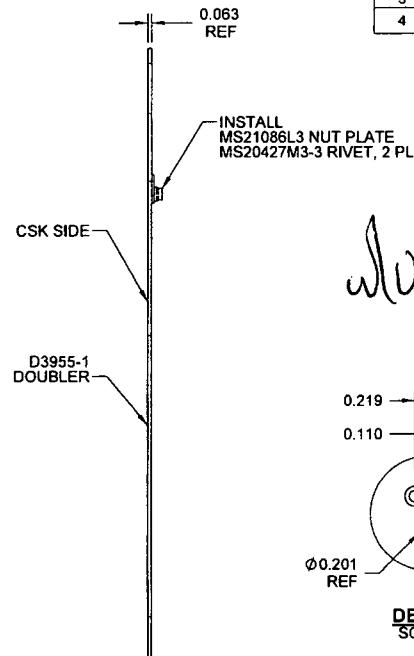
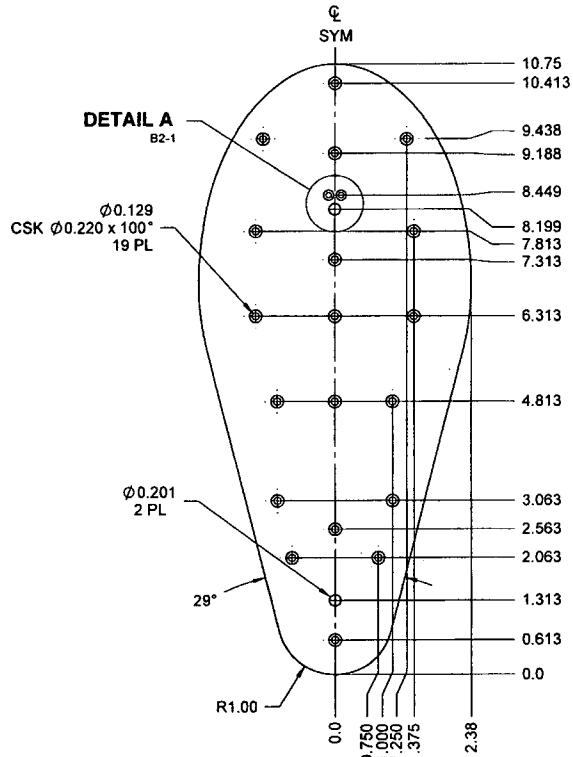
3

2

1

D

D



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S-063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
(09/07/21)

A	NEW ISSUE	RF	09.07.21
REV.	DS ₁	DESCRIPTION	BY DATE
DESIGN	DS ₁	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3955	REV. A
APPROVED		TITLE	SHEET 1 OF 5
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

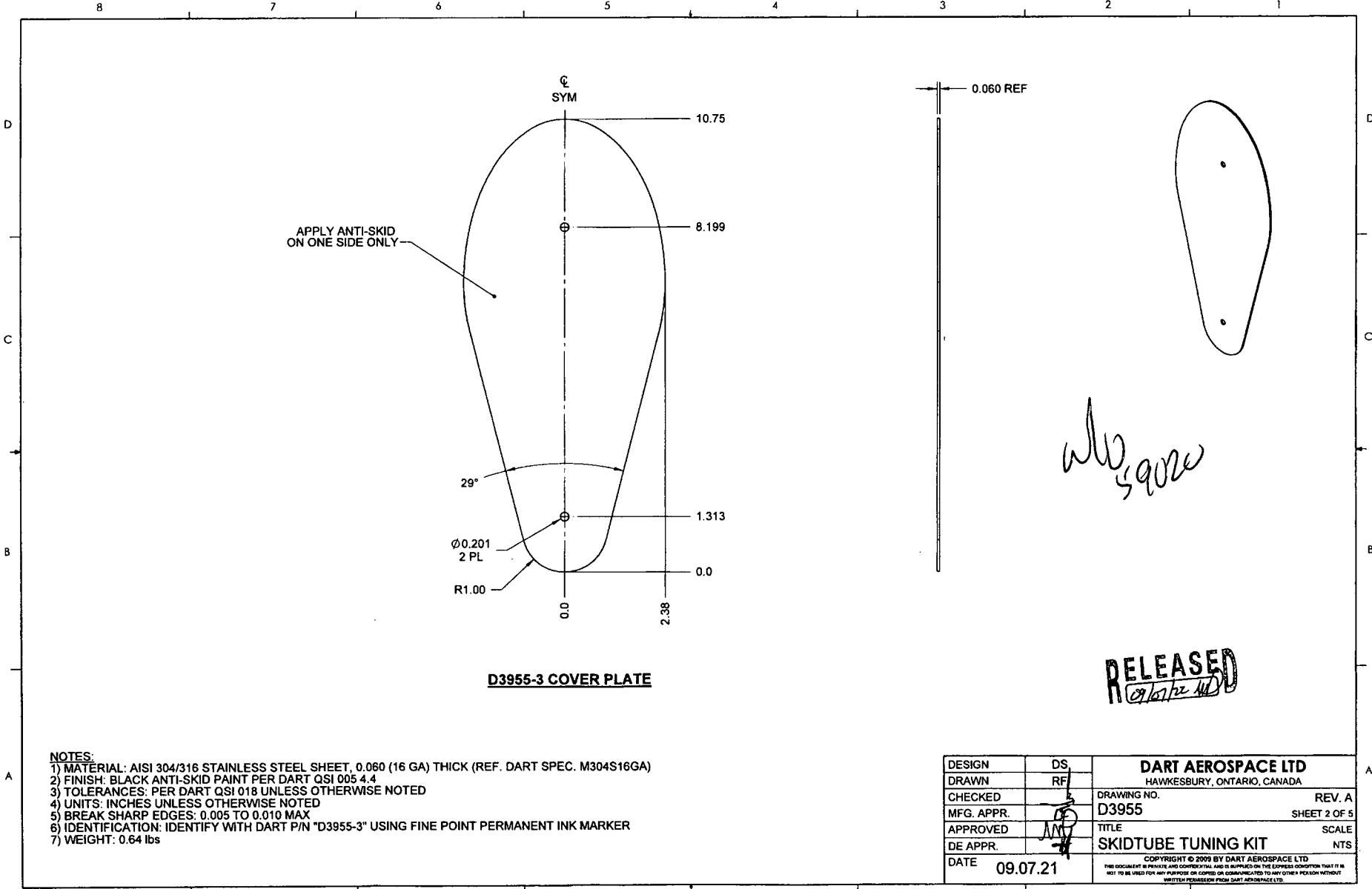
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CHECKED		DRAWING NO.	
MFG. APPR.		REV. A	
APPROVED		D3955	
DE APPR.		TITLE	
		SKIDTUBE TUNING KIT	
DATE	09.07.21	SCALE	
		NTS	

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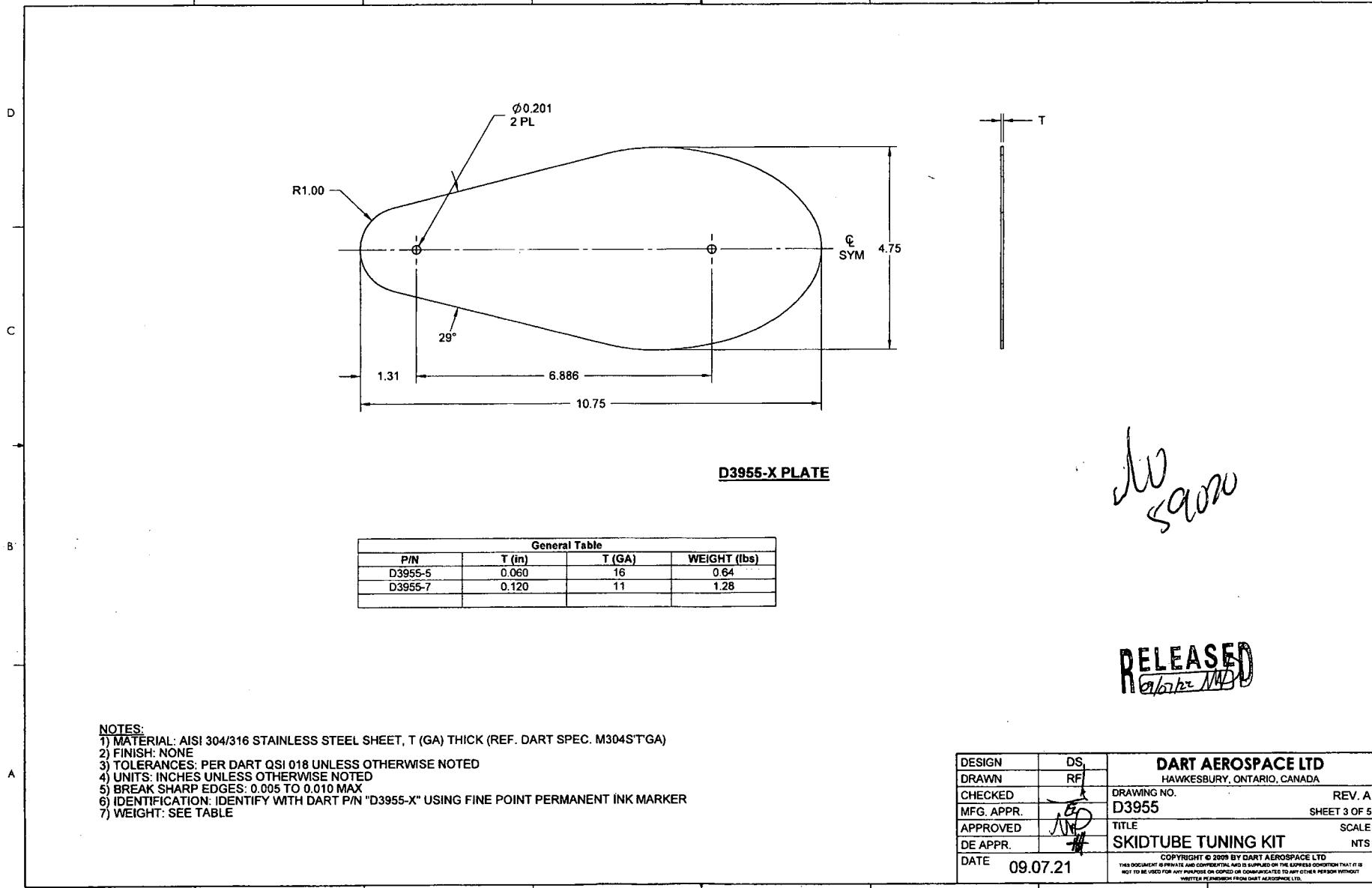
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8 7 6 5 4 3 2 1



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MFG. APPR.		REV. A
APPROVED		D3955 SHEET 3 OF 5
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B

A

JW 5/20/20

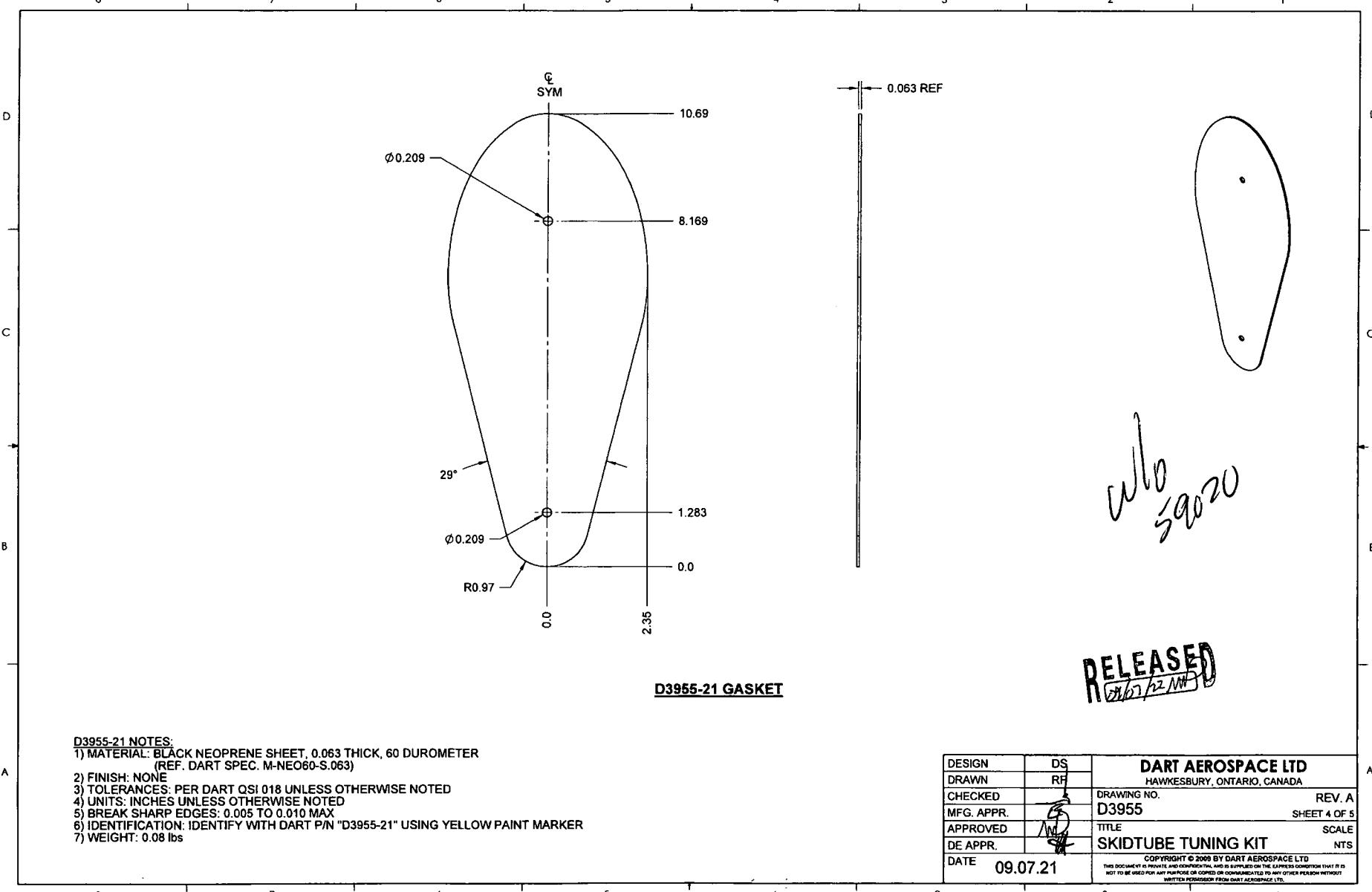
RELEASED
06/22/2021

W/O:		WORK ORDER CHANGES					
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